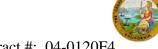
#### DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES Office of Structural Materials Quality Assurance and Source Inspection

Bay Area Branch 690 Walnut Ave.St. 150 Vallejo, CA 94592-1133 (707) 649-5453 (707) 649-5493



Contract #: 04-0120F4

Cty: SF/ALA Rte: 80 PM: 13.2/13.9

File #: 99.28

## WELDING INSPECTION REPORT

Resident Engineer: Casey, William **Report No:** WIR-028358 Address: 333 Burma Road **Date Inspected:** 05-Sep-2012

City: Oakland, CA 94607

**Project Name:** SAS Superstructure OSM Arrival Time: 1000 **OSM Departure Time:** 1830 **Prime Contractor:** American Bridge/Fluor Enterprises, a JV

American Bridge Manufacturing Contractor: **Location:** Reedsport, OR

**CWI Name:** Jim Vanek **CWI Present:** Yes No **Inspected CWI report:** Yes N/A **Rod Oven in Use:** Yes No No N/A N/A **Electrode to specification:** Yes No Weld Procedures Followed: Yes No N/A **Qualified Welders:** Yes No N/A **Verified Joint Fit-up:** Yes No N/A N/A Yes N/A **Approved Drawings:** Yes No **Approved WPS:** No **Delayed / Cancelled:** Yes N/A No

34-0006 **Bridge No: Component:** Split Collars

### **Summary of Items Observed:**

This Quality Assurance Inspector (QAI), Dan Chang, witnessed Quality Control Inspector (QCI), Jim Vanek, of American Bridge Manufacturing (ABM) monitored the repair welding of split collars of CCO 223. QCI was witnessed to monitor welding amperage, 155, and voltage, 13.7, with an Amprobe Model ACDC-100. Repair welding was performed by Gas Tungsten Arc Welding (GTAW) using ER70S-2 3/32" diameter electrode in accordance to Welding Procedure Specification (WPS) # ABM-GTAW-01. This QAI witnessed Ben Price to grind off rust within the void to bright metal and preheat to at least 250°F prior to welding using Extech mini-infrared thermometer Model 42500. This QAI verified amperage and voltage with Fluke ammeter Model 337. Repair welding on split collars were observed at regular intervals by this QAI.

Split collars from Group 5 that were completed repairing during this work shift are BIF-066-11, BIF-134-23, BIF-077-13, and BIF-523-88.

# WELDING INSPECTION REPORT

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| Iter | n Weld Identification | Applicable WPS | CWI Name  | Amperage | Voltage | TravelSpeed | Preheat Temp | Remarks            |
|------|-----------------------|----------------|-----------|----------|---------|-------------|--------------|--------------------|
| 1    | BIF-066-11            | ABM-GTAW-01    | Jim Vanek | 155      | 13.7    | 3 ipm       | 250          | Void was welded    |
|      |                       |                |           |          |         |             |              | and surface ground |
|      |                       |                |           |          |         |             |              | smooth             |
| 2    | BIF-523-88            | ABM-GTAW-01    | Jim Vanek | 155      | 13.7    | 3 ipm       | 250          | Void was welded    |
|      |                       |                |           |          |         |             |              | and surface ground |
|      |                       |                |           |          |         |             |              | smooth             |
| 3    | BIF-077-13            | ABM-GTAW-01    | Jim Vanek | 155      | 13.7    | 3 ipm       | 250          | Void was welded    |
|      |                       |                |           |          |         |             |              | and surface ground |
|      |                       |                |           |          |         |             |              | smooth             |
| 4    | BIF-134-23            | ABM-GTAW-01    | Jim Vanek | 155      | 13.7    | 3 ipm       | 250          | Void was welded    |
|      |                       |                |           |          |         |             |              | and surface ground |
|      |                       |                |           |          |         |             |              | smooth             |

## **Summary of Conversations:**

No significant conversations occurred today.

### **Comments**

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Gary Thomas, (916) 764-6027, who represents the Office of Structural Materials

# WELDING INSPECTION REPORT

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for your project.

**Inspected By:** Chang,Dan Quality Assurance Inspector

**Reviewed By:** Riley,Ken QA Reviewer